

# Work Order ID 108313

\*108313\*

Page 1

Wednesday, October 16, 2013 8:56:12 AM

Item ID: D3121-241 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bearing Assembly  
 Start Date: 10/16/2013 Start Qty: 50.00 \*50\* Cust Item ID:  
 Required Date: 10/16/2013 Req'd Qty: 50.00 \*50\* Customer:  
 Reference:

Approvals: Process Plan: WME Date: 13-10-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3121	Rev E								

130 0.00  
 \*130\* Small Fab  
 Small Fab Memo 0.00  
 Small Fab 1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

140 0.00  
 \*140\* QC5- Inspect part completeness to step on W/O  
 QC Memo 0.00  
 Quality Control

150 0.00  
 \*150\* Identify as per dwg & Stock Location: ST235  
 Packaging Memo 0.00  
 Packaging

SO 13/10/16

SO con

50x 13-10-16  
 DAS 28 9-89

**Work Order ID 108313****\*108313\***

Page 2

Wednesday, October 16, 2013 8:56:12 AM

Item ID: D3121-241 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bearing Assembly  
Start Date: 10/16/2013 Start Qty: 50.00 **\*50\*** Cust Item ID:  
Required Date: 10/16/2013 Req'd Qty: 50.00 **\*50\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

*Handwritten signature and date: 10/13-10-17*

*Handwritten date: 10/13-10-17*

# Picklist Print

Wednesday, October 16, 2013 8:56:11 AM

Page 1

Work Order ID: 108313  
 Parent Item: D3121-241  
 Parent Item Name: Bearing Assembly

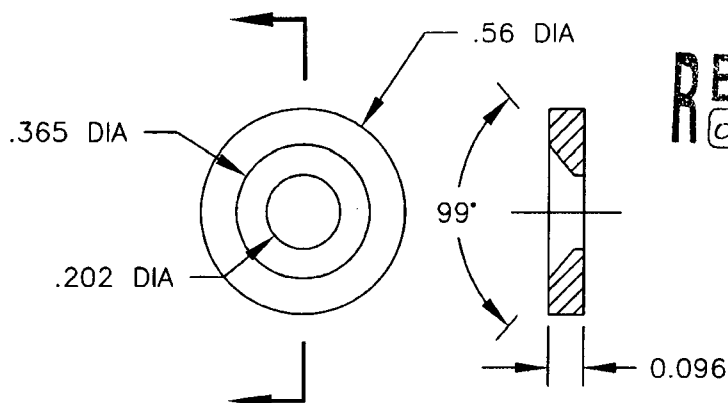
Start Date: 10/16/2013 Required Date: 10/16/2013  
 Start Qty: 50.00 Required Qty: 50.00

Comments: IPP Rev:A04.02.18New issueKJ/DS  
 IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

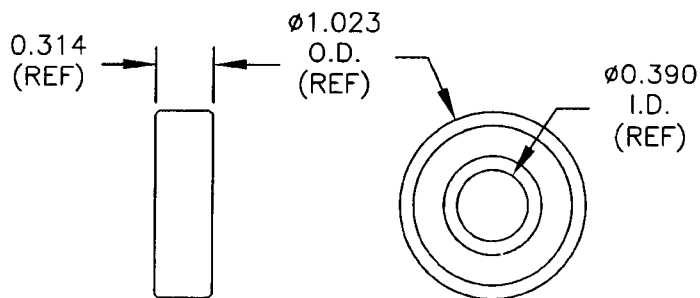
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-25 Delrin Cap		Manufactured	No				Each	182.0000		50		13/10/16	DAS 36 9.89
				<u>Location</u>				<u>Loc Qty</u>					
				ST235				182					
				102340				27					
				102767				60					
				105445				95		50			
D3121-23 Bearing		Manufactured	No			130	Each	107.0000	1	50		13/10/16	DAS 36 9.89
				<u>Location</u>				<u>Loc Qty</u>					
				ST235				107					
				105954				33		33			
				108218				60		17			
				66734				10					
				75084				2					
				99000				2					

**DART**

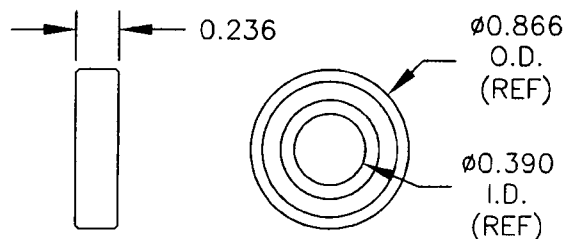
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

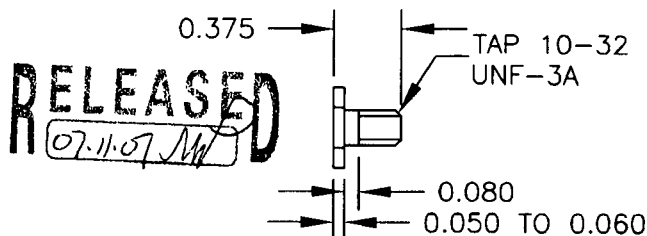
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

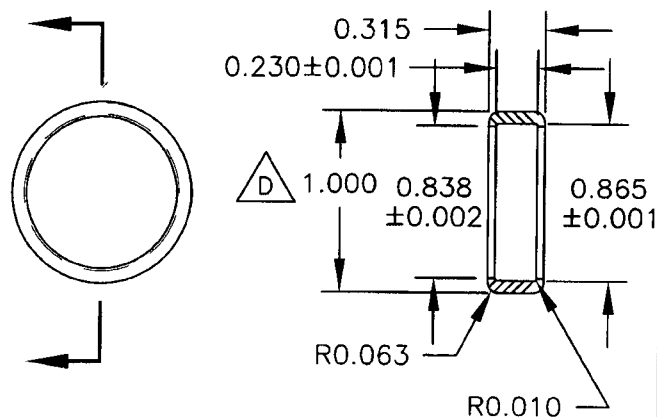
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

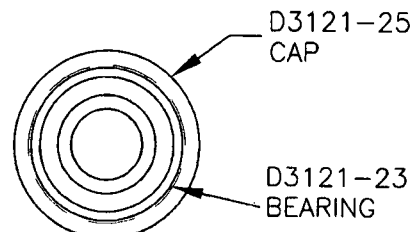
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

#108332

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.